

Date: Thursday, 15/01/2009 11:15:15 AM
 User: Julie Dawson

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PANEL-350 AFT CANOPY
 Job Number : 44820 -2
 Estimate Number : 13098
 P.O. Number :
 This Issue : 15/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : THERMOFORMING
 Previous Run : 42208
 Part Number : D36561
 Drawing Number : D3656 REV B
 Project Number : 00204
 Drawing Revision : B
 Material :
 Due Date : 05/02/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 09.01.15
 Comment : Est. Rev. A 07/12/13 New issue DL verified by:DD
 Est. Rev. B 08/09/25 Dwg. Update DL.

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MLEXS093F600607 GE PLASTICS LEXAN SHEET



Comment: Qty.: 32.0000 sf(s)/Unit Total : 128.0000 sf(s)

GE PLASTICS LEXAN SHEET

batch: M105494

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

BB 09/01/23

(X4)

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 8986

Dwg. Rev. B

Folio Rev. A

BB 09/01/23

(X4)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/01/23

Date: Thursday, 15/01/2009 11:15:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 AFT CANOPY

Job Number: 44820

Part Number: D36561

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09/01/26 (X)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

DD 09/01/26

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

DD 09/01/26

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/26 (X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP44641

SS 09/01/26 (X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/27 (X)

Job Completion



09.01.27

DART AEROSPACE LTD		Work Order: 44820
Description: Panel		Part Number: D3656-1
Inspection Dwg: D3656	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: BB Date: 09/01/26

TRIMMING SECTION

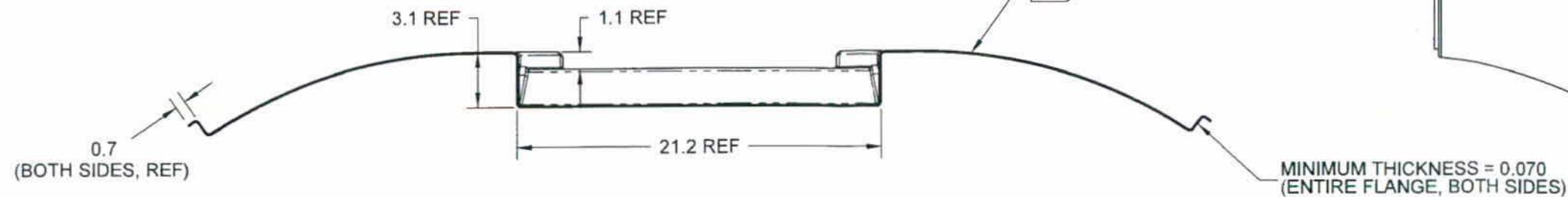
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.7	+/-0.030	.7	✓			
0.070	Min	.087	✓			
0.050	Min	.067	✓			

Measured by: BB Date: 09/01/26

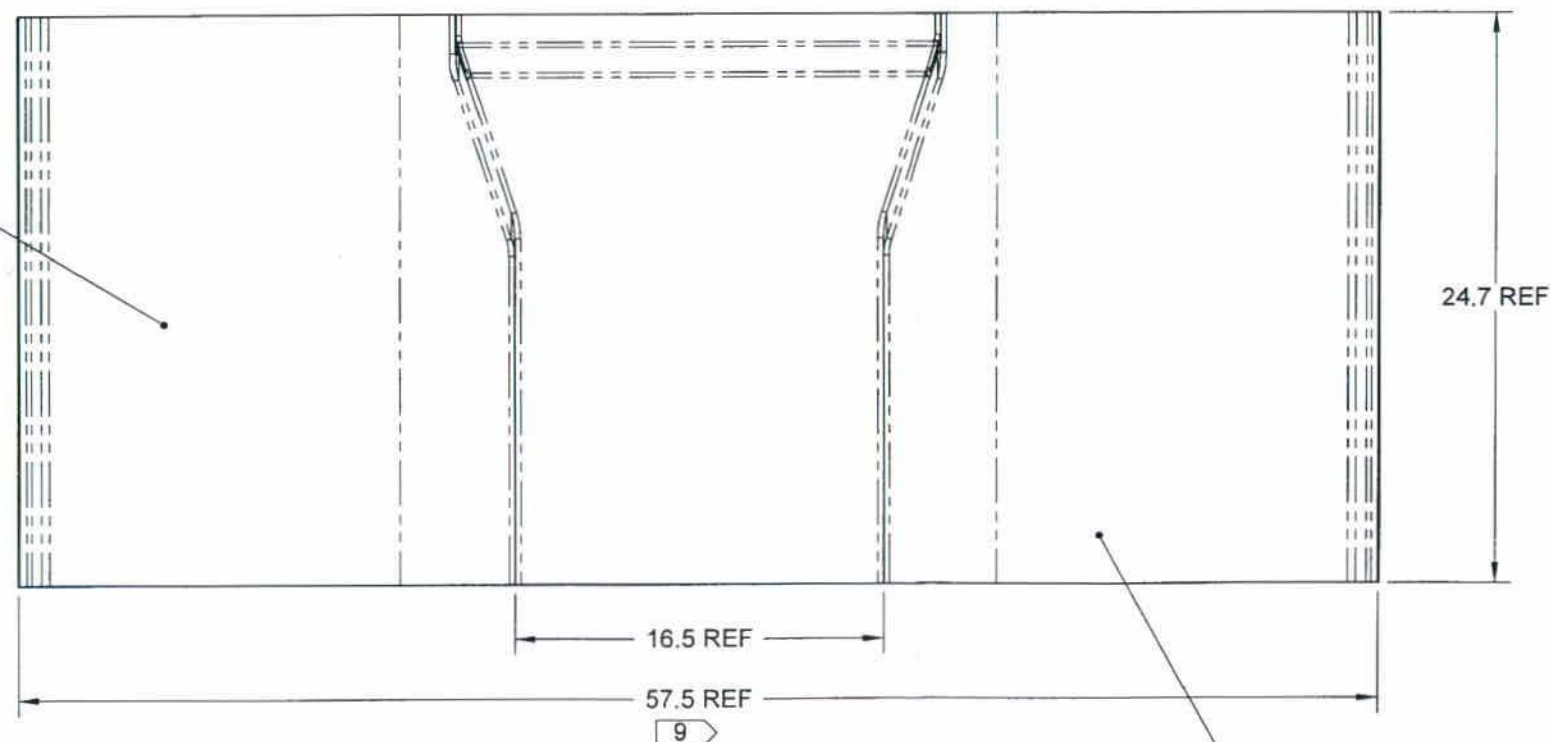
Audited by: e Date: 09/01/26

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	AK



TEXTURED SURFACE
ON THIS SIDE



D3656-1 PANEL

MINIMUM THICKNESS = 0.050
(ALL OVER EXCEPT WHERE NOTED)

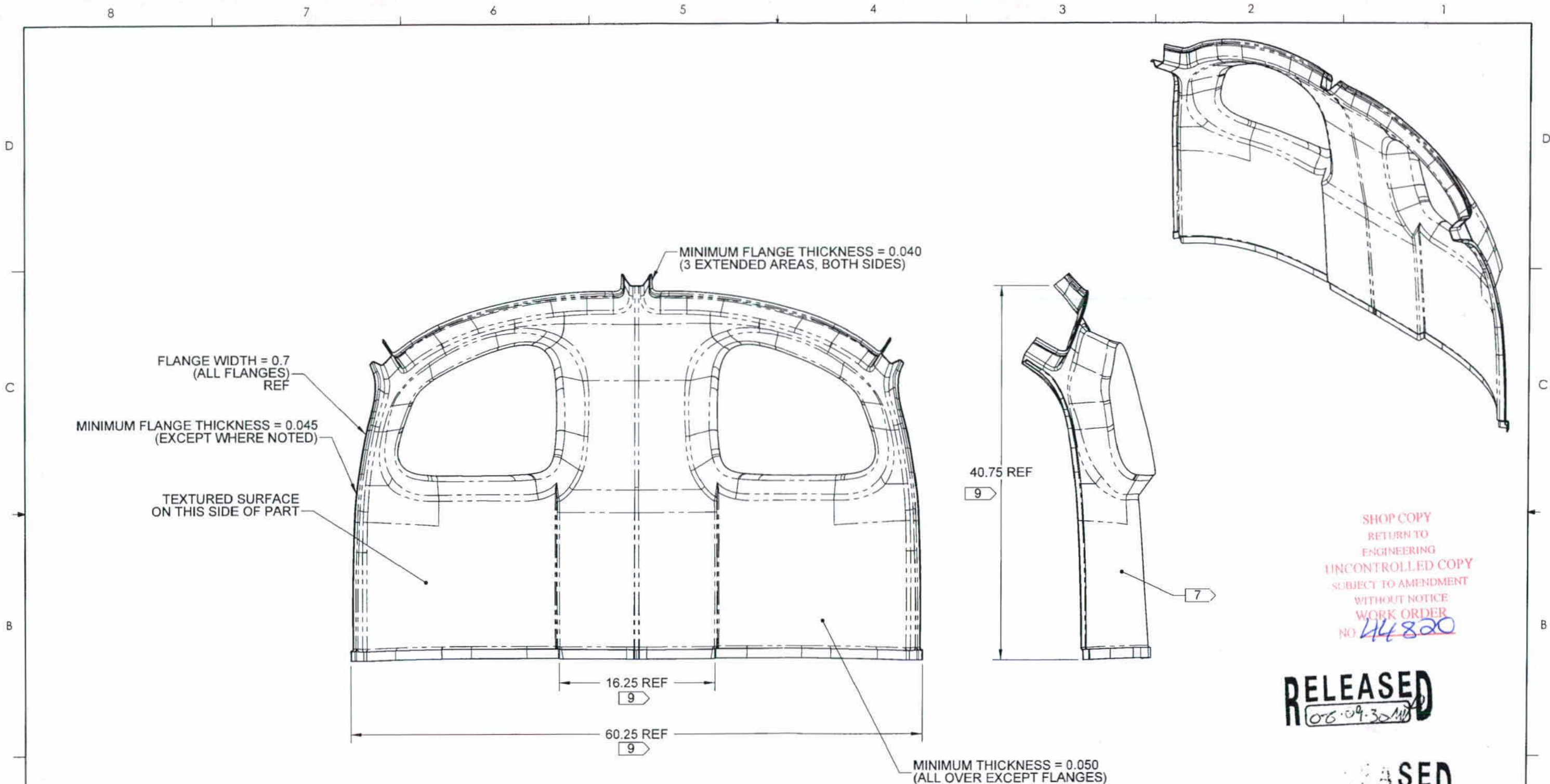
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44820

RELEASED
08-09-30 11:10

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022
TRIM PER DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

B	REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2); REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST	PH	08.09.18
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.18		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3656 TITLE PANEL COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
		REV. B	SHEET 1 OF 2
		SCALE	NTS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 44820

RELEASED
08-09-30-18

RELEASED

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022 TRIM PER DT8987
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 8.7 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	CE	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JL	DRAWING NO.	REV. B
MFG. APPR.	44	D3656	SHEET 2 OF 2
APPROVED	44	TITLE	SCALE
DE APPR.	44	PANEL	NTS
DATE	08.09.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

111015